

Date: Monday, 26/01/2009 11:38:50 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT LEG ASSY
Job Number : 45232	
Estimate Number : 13176	
P.O. Number :	Part Number : D3684049
This Issue : 26/01/2009 S.O. No. :	Drawing Number : D3684 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 44682	Material :
Written By :	Due Date : 28/01/2009 Qty: 2 Um: Each
Checked & Approved By : <u>MF 09-01-26</u>	
Comment : Est Rev:A new issue 08-02-12 DD verified by:JLM Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC Est Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

2.0	D36883	STUD
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

STUD

batch B44824MF 09-01-28

3.0	D36891	SLEEVE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SLEEVE

batch B44682MF 09-01-28

4.0	D36911	STUD
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

STUD

batch B44688MF 09-01-28

5.0	D36921	SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

SPACER

batch B44527MF 09-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 26/01/2009 11:38:51 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT LEG ASSY

Job Number: 45232

Part Number: D3684049

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D36931	Rod End Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rod End Bearing

batch p44691

MF 09-01-27

7.0	AN3C12A	Bolts
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolts

batch m106993

MF 09-01-27

8.0	MS210433	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch ~~1010023~~ 110023

MF 09-01-27

9.0	NAS509L12C	Nuts
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nuts

batch m106993

MF 09-01-27

10.0	NAS50912C	Nuts
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nuts

batch m106993

MF 09-01-27

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fasteners as per Dwg D3684

MF 090128 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 26/01/2009 11:38:51 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT LEG ASSY

Job Number: 45232

Part Number: D3684049

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5026128 (2)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: _____

45215, 45216

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/29

Job Completion



MF 69-01-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

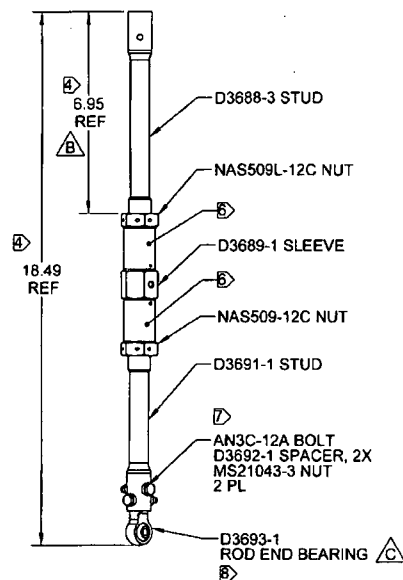
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
09/01/12 MJD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3684	REV. C
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	